

Work Order ID 75235

75235

RUSH

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Wednesday, October 19, 2011 11:07:54 AM

Item ID: D2661-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, LH Fwd Aft Out 206
 Start Date: 10/19/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 10/20/2011 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: *YMF* Date: *11-10-19* Tooling: Date:
 QC: Date: SPC (Y/N): Date:
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2661	Rev D								

100		0.00							
100	HAAS CNC VERTICAL MACHINING #1		<i>29</i>	<i>11-10-19</i>		<i>6</i>	<i>0</i>		
HAAS I	Memo	0.00							
HAAS CNC vertical machine #1	Program part number and batch number.		<i>JK</i>	<i>conf</i>					
	Program part number and batch number								
	MACHINE AS PER DWG AND FOLIO FB073								
	FOLIO REV: <i>HA</i>								
	DWG REV: <i>5</i>								
110		0.00							
110	CONVENTIONAL MILLING MACHINE		<i>29</i>	<i>11-10-19</i>		<i>6</i>	<i>0</i>		
Mill Conv	Memo	0.00							
Conventional Milling Machine	Machine Keyway and inspect per attached dimension sheet		<i>JK</i>						

W/O: 175235

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2661-1 PAR #: _____ Fault Category: Machining NCR: Yes No DQA: A Date: 11/10/25
 Resolution: scrap Disposition: Scrap QA: N/C Closed: OK Date: 11/10/25

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/10/19	100	1" ball nose plunge into the crosstube island make a big mark .500" by .183" P.C. machine error.	<u>[Signature]</u> 11/10/19	scrap and destroy replace Qty 1 Batch <u>73780</u>	<u>mf</u> 11/10/20	B.A 11/10/20	<u>[Signature]</u> 11/10/19	<u>S</u> 11/10/20

NOTE: Date & initial all entries

Work Order ID 75235***75235***

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Wednesday, October 19, 2011 11:07:54 AM

Item ID: D2661-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 10/19/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/20/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat									
Powder Coating									
MU7745	Memo	7:45							
	START TIME:								
	FINISH TIME:								
		8:15							

160	QC3- Inspect Part Finish	0.00							
160									
QC									
Quality Control									
	Memo	0.00							

170	Identify as per dwg & Stock Location: 435	0.00							
170									
Packaging									
Packaging									
	Memo	0.00							

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6 Ø M 11/10/20
counted

11/10/20 SP (6)

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Wednesday, October 19, 2011 11:07:54 AM

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

11/10/20 *[Signature]*
MF
11-10-20

Picklist Print

Wednesday, October 19, 2011 11:07:53 A

Page 1

Work Order ID: 75235

Parent Item: D2661-1

Parent Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 10/19/2011

Required Date: 10/20/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house processEC
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003 Saddle Billet, 7075		Manufactured	No			100	Each	71.0000	1	6			

29 6 W. 10-19

Location	Loc Qty	Loc Code
MAT040	68	
72226	8	
73775	60	
MAT44	3	
72226	2	
73769	1	
73780		

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DART AEROSPACE LTD		Work Order: 75235
Description: 206 Saddle, Outboard, Left side		Part Number: D2661-1
Inspection Dwg: D2661 Rev. D		Page 1 of 1

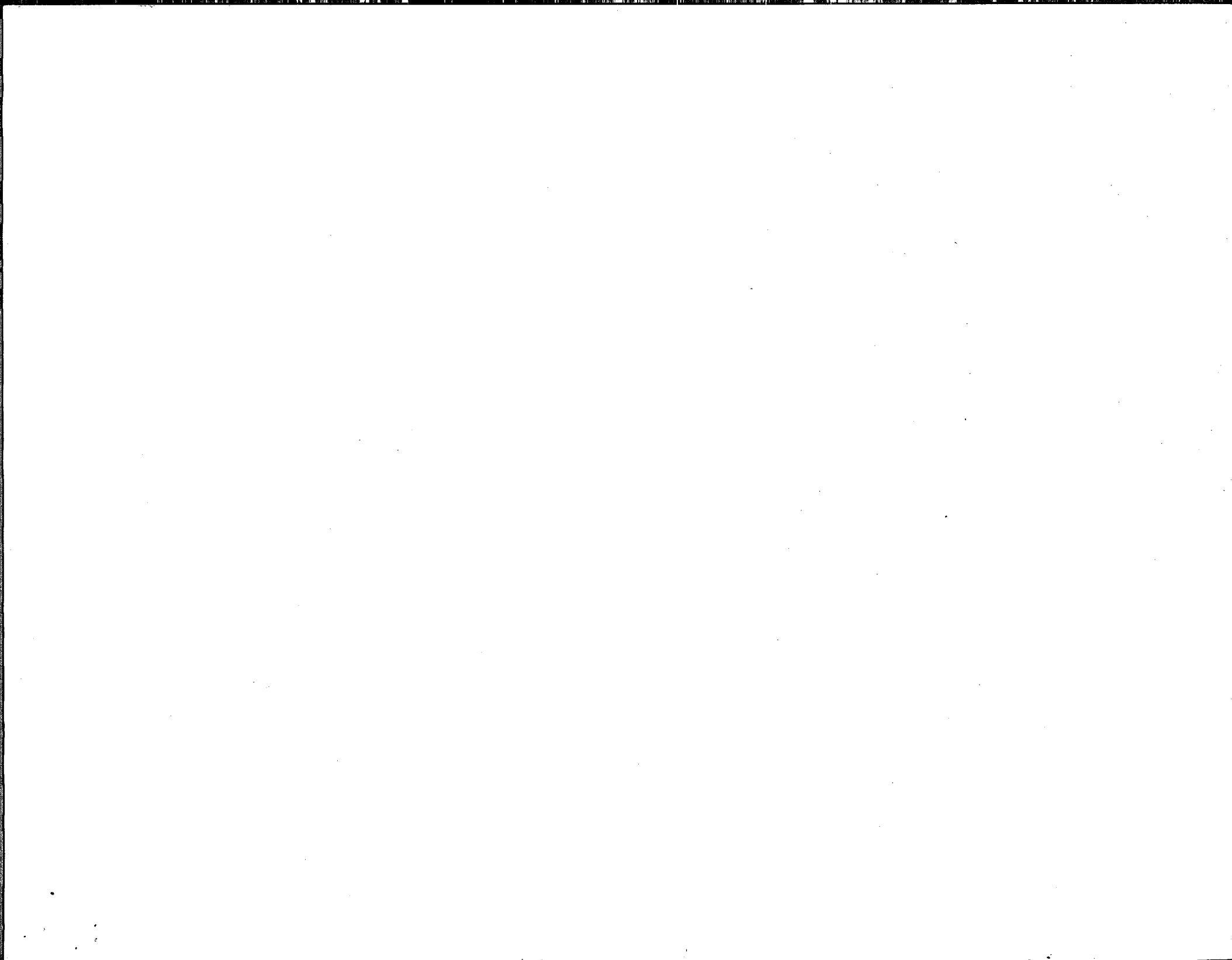
Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.138	.133	.130	.130		
B	0.100	0.140		.124	.124	.124	.125		
C	1.250	1.270		1.136	1.137	1.137	1.137		
D	0.615	0.685		.685	.685	.685	.685		
E	0.240	0.260		.257	.252	.257	.252		
F	1.437	1.467		1.331	1.325	1.325	1.325		
G	0.210	0.230		.230	.225	.225	.225		
H	0.100	0.180		.125	.140	.140	.140		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.573	1.574	1.575	1.576		
K	0.235	0.240		.237	.237	.238	.238		
L	0.100	0.120		.107	.109	.110	.110		
M	0.990	1.010		1.000	1.004	1.000	1.000		
N	0.510	0.515		.511	.572	.512	.512		
O	5.990	6.010		6.000	5.997	5.996	5.996		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.315	.315	.315	.313		
S	0.315	0.322		.317	.317	.317	.317		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.363	1.363	1.363	1.363		
V	0.787	0.807		.796	.796	.798	.791		
W	0.540	0.560		.549	.545	.549	.549		
X	1.674	1.684		1.679	1.680	1.680	1.680		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.915	.915	.920	.918		
AA	0.490	0.510		.492	.499	.497	.498		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: *[Signature]*
Date: 11/10/20 / 11-10-20

Audited by: *[Signature]*
Date: 11/10/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	



DART AEROSPACE LTD	Work Order: 75235
Description: 206 Saddle, Outboard, Left side	Part Number: D2661-1
Inspection Dwg: D2661 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

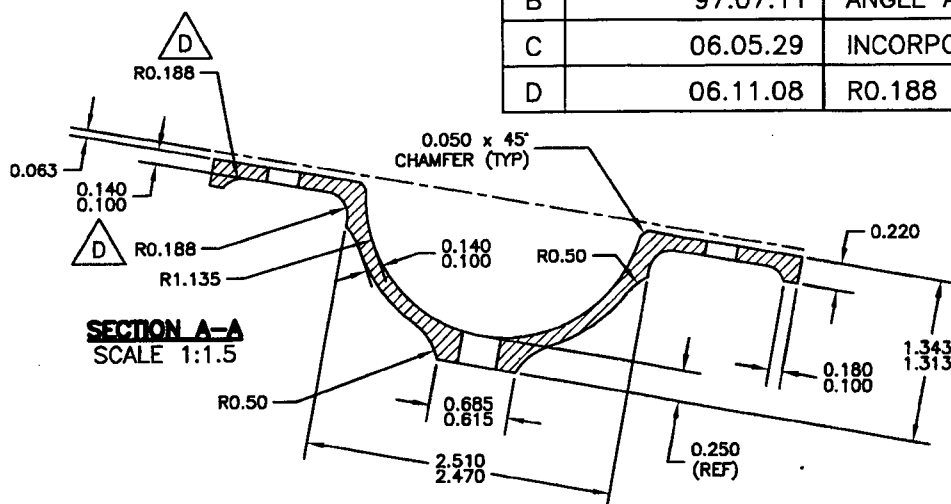
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	26	3	4	By	Date
A	0.100	0.140		.130	.128				
B	0.100	0.140		.125	.125				
C	1.250	1.270		1.137	1.138				
D	0.615	0.685		.685	.685				
E	0.240	0.260		.252	.254				
F	1.437	1.467		1.325	1.325				
G	0.210	0.230		.225	.225				
H	0.100	0.180		.140	.140				
I	2.470	2.510		2.490	2.490				
J	1.565	1.585		1.575	1.578				
K	0.235	0.240		.238	.238				
L	0.100	0.120		.109	.110				
M	0.990	1.010		1.000	1.000				
N	0.510	0.515		.512	.512				
O	5.990	6.010		5.996	5.996				
P	1.245	1.255		1.250	1.250				
Q	2.495	2.505		2.500	2.500				
R	0.313	0.318		.313	.313				
S	0.315	0.322		.317	.317				
T	2.495	2.505		2.500	2.500				
U	1.357	1.367		1.362	1.362				
V	0.787	0.807		.792	.792				
W	0.540	0.560		.548	.546				
X	1.674	1.684		1.679	1.679				
Y	0.257	0.262		.258	.258				
Z	0.912	0.932		.920	.922				
AA	0.490	0.510		.498	.496				
AB	0.178	0.198		.188	.188				
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>ML</i>	Audited by: <i>MA</i>
Date: 11/10/20	Date: 11/10/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART

DESIGN	<i>#</i>	DRAWN BY	<i>CB</i>	DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED	<i>PH</i>	APPROVED	<i>#</i>	DRAWING NO.	REV. D
				D2661	SHEET 1 OF 1
DATE	06.11.08			TITLE	SCALE
				SADDLE OUTSIDE	1:3
A	97.03.25			NEW ISSUE	
B	97.07.11			ANGLE AND NOTES ADDED	
C	06.05.29			INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08			R0.188 WAS R0.30; $\phi 0.316$ WAS $\phi 0.313$	

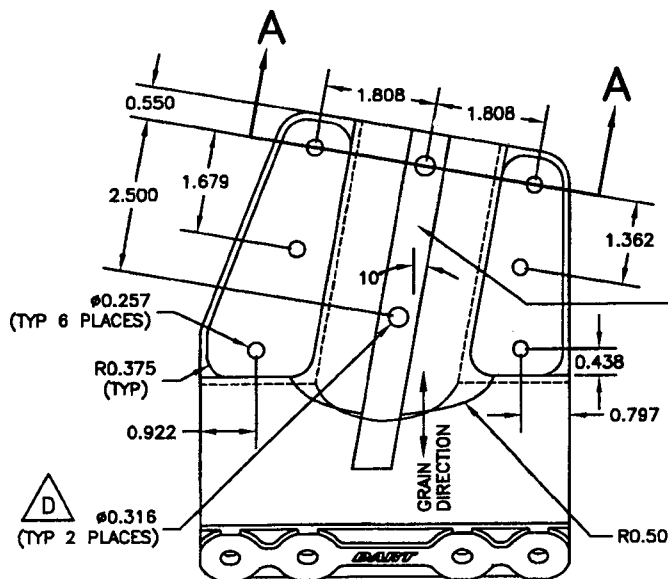


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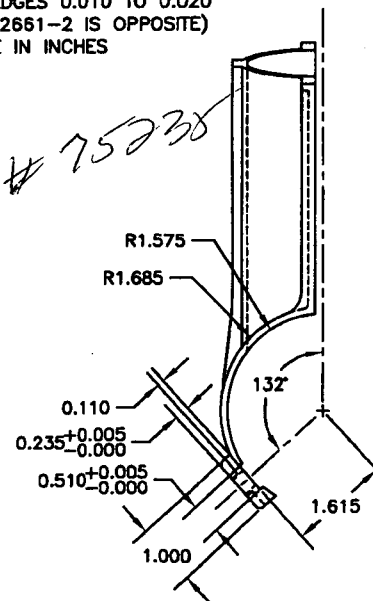
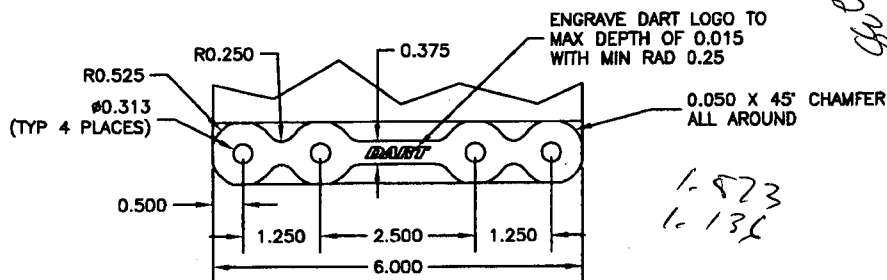
07.02.12 *#*

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2661-1 SHOWN (D2661-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010

**D2661-1 SADDLE OUTSIDE**

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